

Date: Thursday, 1/17/2008 3:24:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLANGE	
Job Number : 36816		
Estimate Number : 12314		
P.O. Number :	Part Number : D34739	OK FOR REV. B 08.01.18
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D3473 REV B	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B	
Previous Run : 34422	Material :	
Written By : <u>08.01.18</u>	Due Date : 2/10/2008	Qty: 10 Um: Each
Checked & Approved By : <u>08.01.18</u>		
Comment : Est Rev:A New Issue 06-03-02 JLM		
Est Rev:B As per Rev B 06-05-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.6305 sf(s)/Unit Total : 6.3053 sf(s)

304/316 0.018 SHEET

Batch: 165591 IB 8-1-23

2.0	WATER JET <u>165591</u>	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: B

Prog Rev: B

IB 8-1-23

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-1-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/4/25 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

IB 8-1-23

2-Form as per Dwg D3473 using DT8860

MF 08-01-30

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 28/02/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:24:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE

Job Number: 36816

Part Number: D34739

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/01/30

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF 08-02-01

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/04

Job Completion



Jim 2008/2/04

(10)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

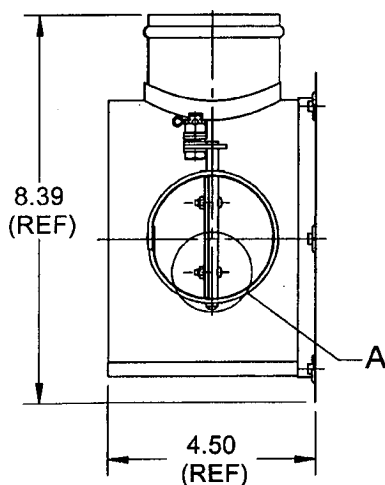
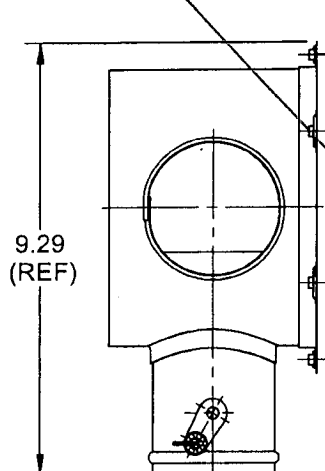
**NOTE:** Date & initial all entries





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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

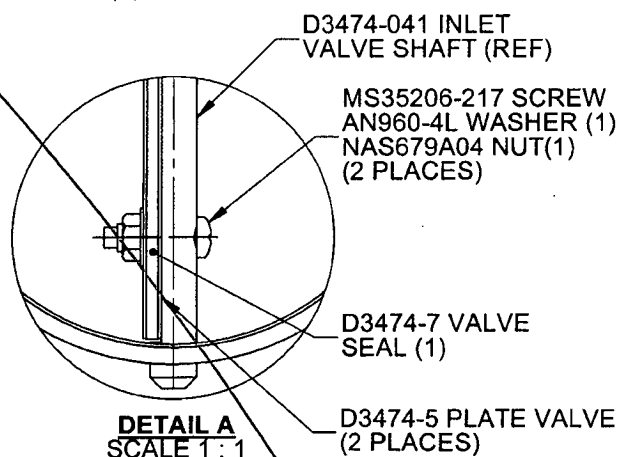
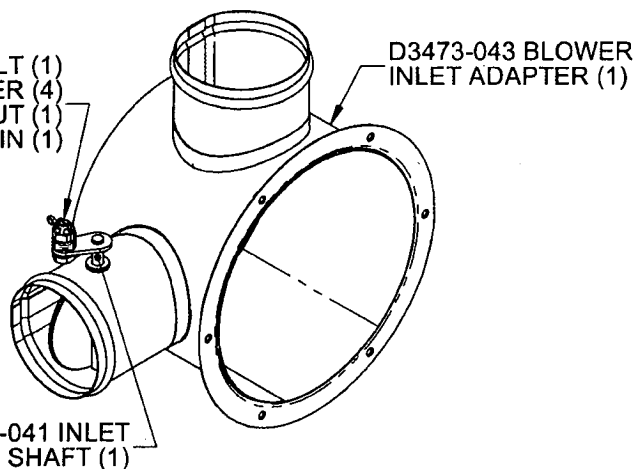
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06-05-16 *[Signature]*



D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)  
MS24665-153 COTTER PIN (1)

**UNDER REVIEW**

*[Signature]*  
Dirt & Manufacturing  
Control



### **D3473-041 BLOWER INLET ADAPTER**

#### **NOTES:**

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT SHOP COPY
2	D3474-5	BUTTERFLY VALVE RETURN TO
1	D3474-7	BUTTERFLY VALVE SEAL ENGINEERING
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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WITHOUT NOTICE  
WORK ORDER  
NO. *36816*

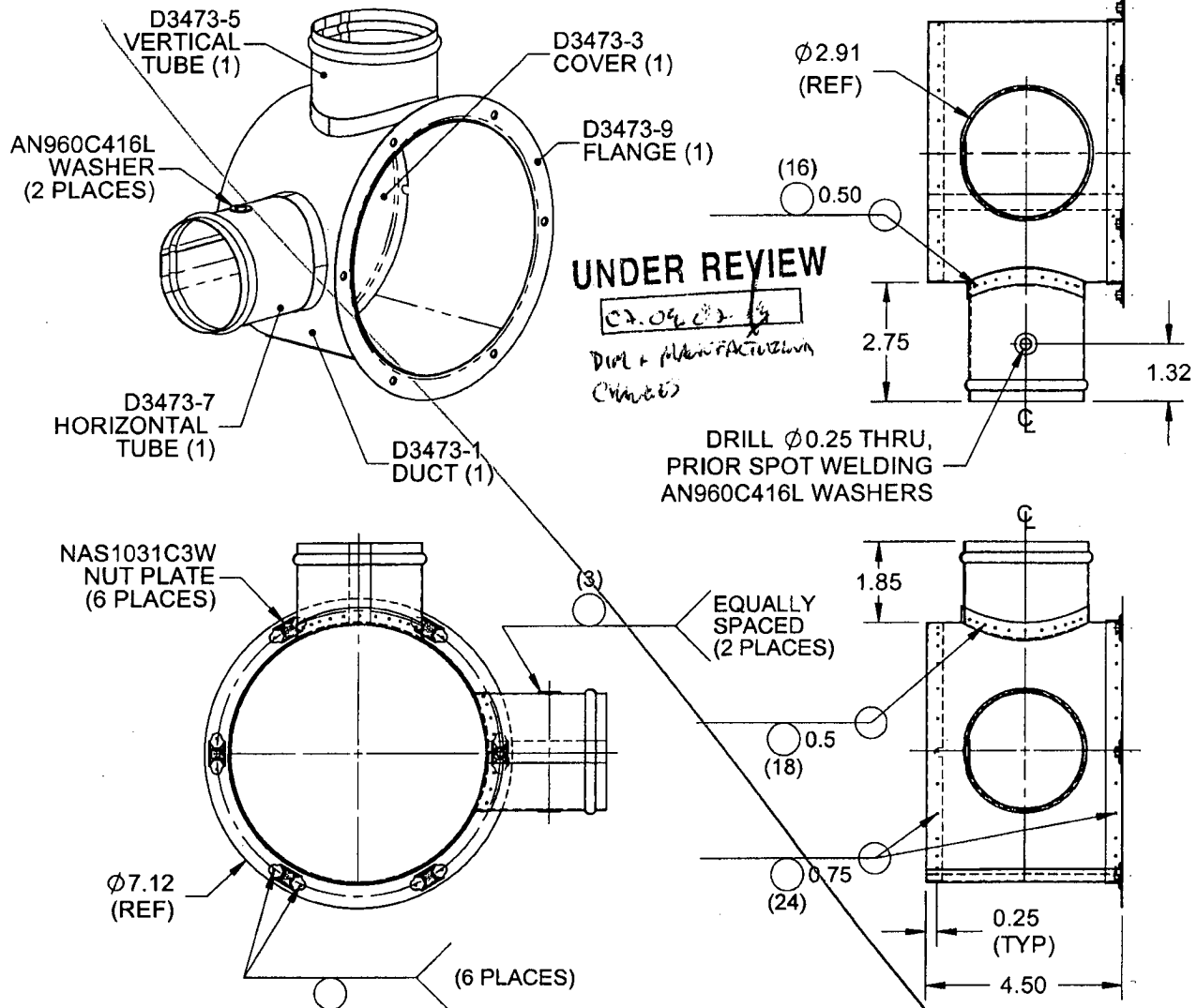
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CHECKED <i>11</i>	APPROVED <i>11</i>	DRAWING NO. <b>D3473</b>	REV. B SHEET 2 OF 7
DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

RELEASED  
06.05.16



### D3473-043 BLOWER INLET WELDMENT

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

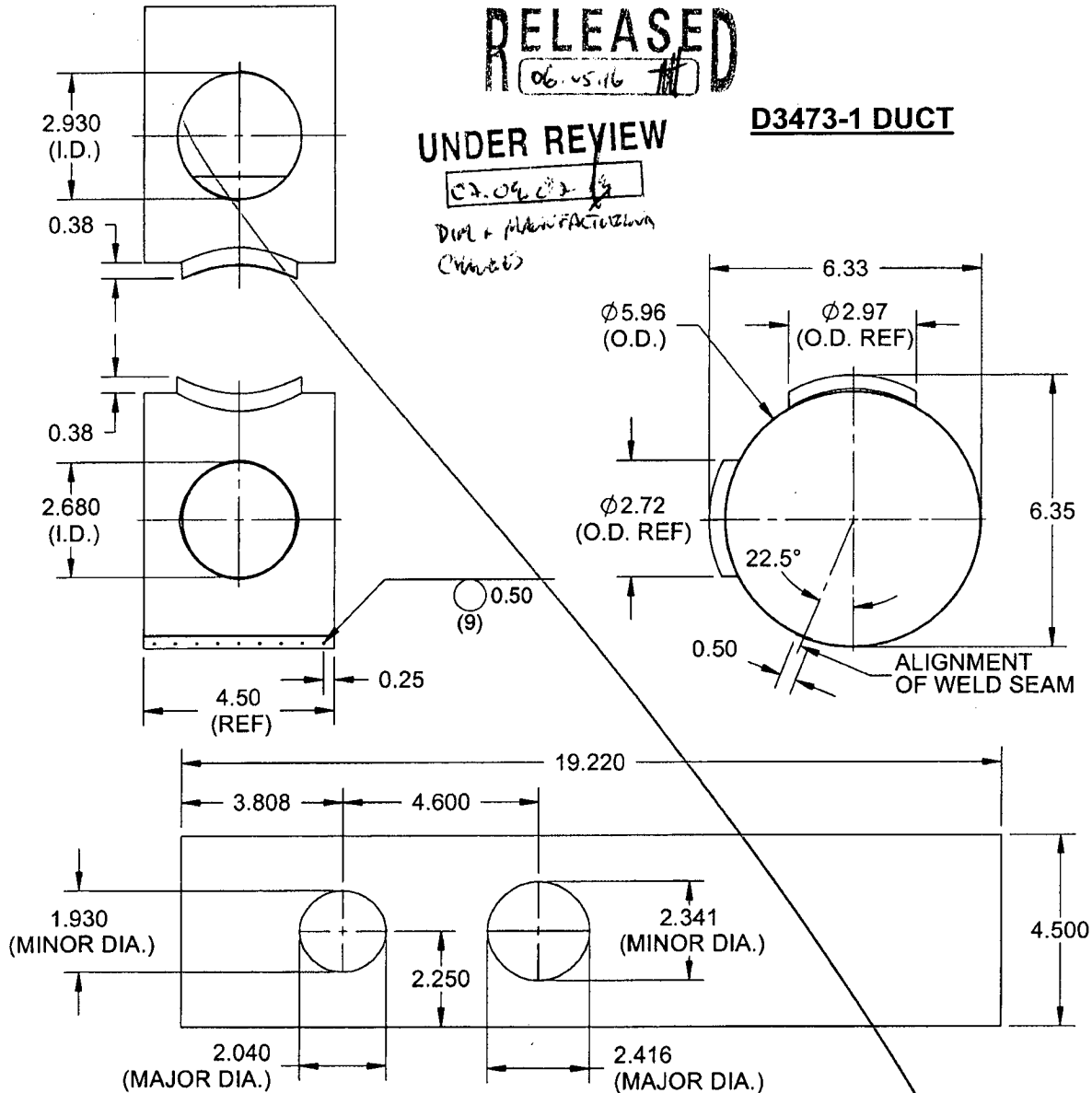
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06.05.16

UNDER REVIEW

02.09.16

DIAL + MANUFACTURING  
CHECKED

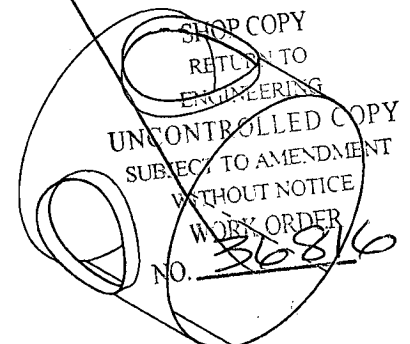
**D3473-1 DUCT**



**D3473-1F DUCT FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



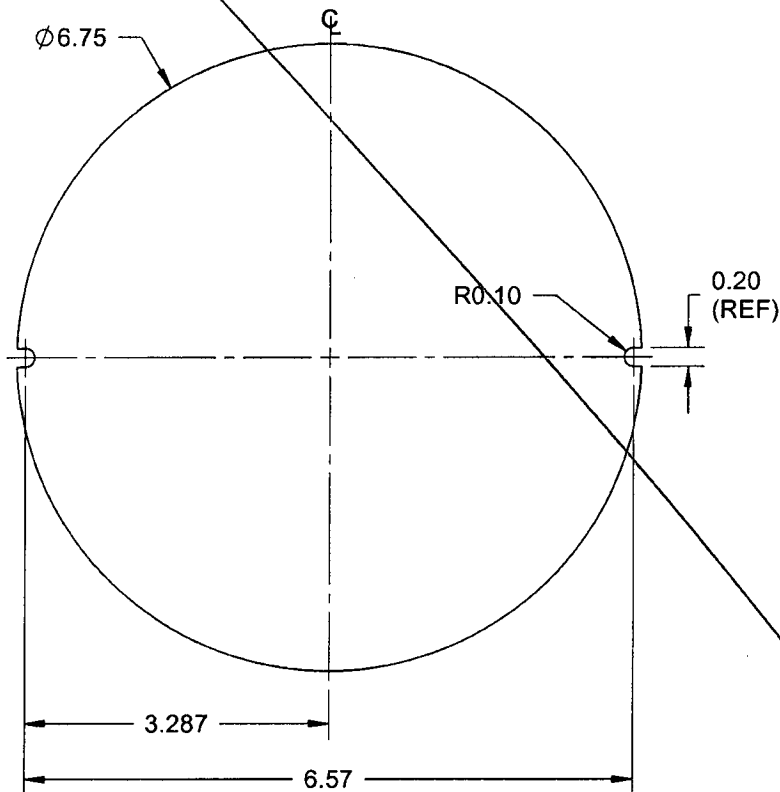
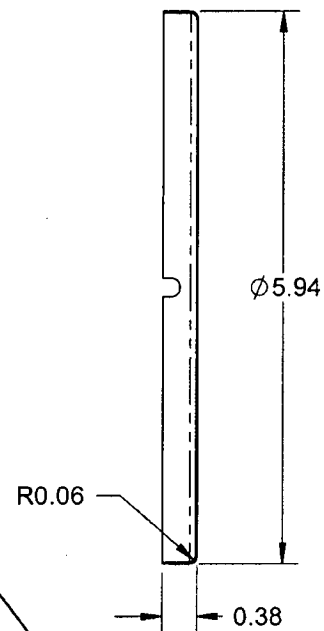
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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

**RELEASED**  
06-05-16 *[Signature]***UNDER REVIEW**02.09.16 *[Signature]*  
DIP + MANUFACTURING  
CHECKS**D3473-3F COVER FLAT PATTERN****D3473-3 COVER****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

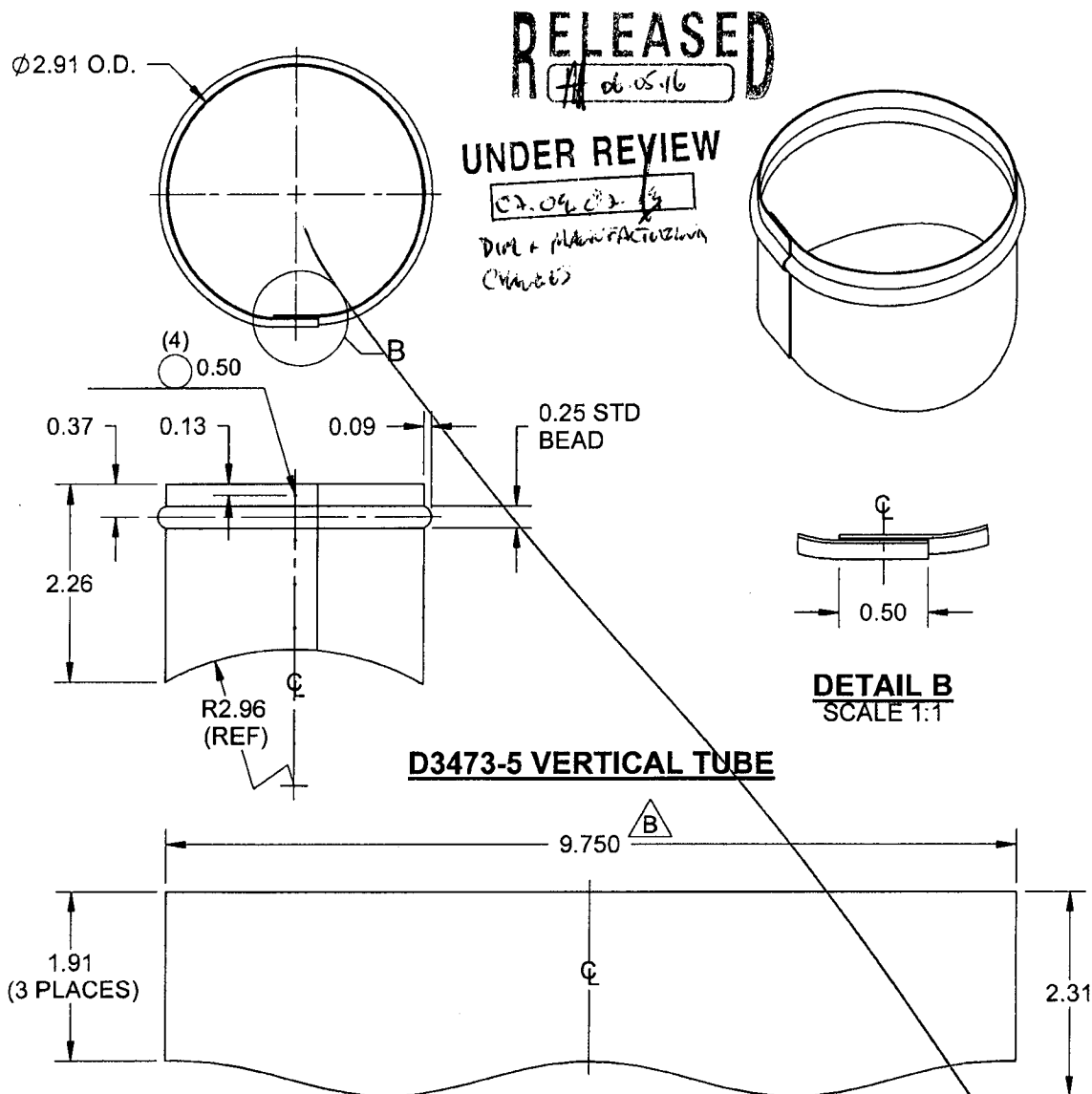
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2



### D3473-5F VERTICAL TUBE FLAT PATTERN

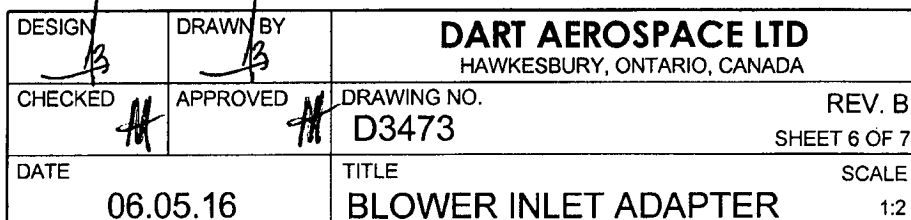
#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED), 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
2) SPOT WELD PER DART QSI 004  
3) FINISH: NONE  
4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES  
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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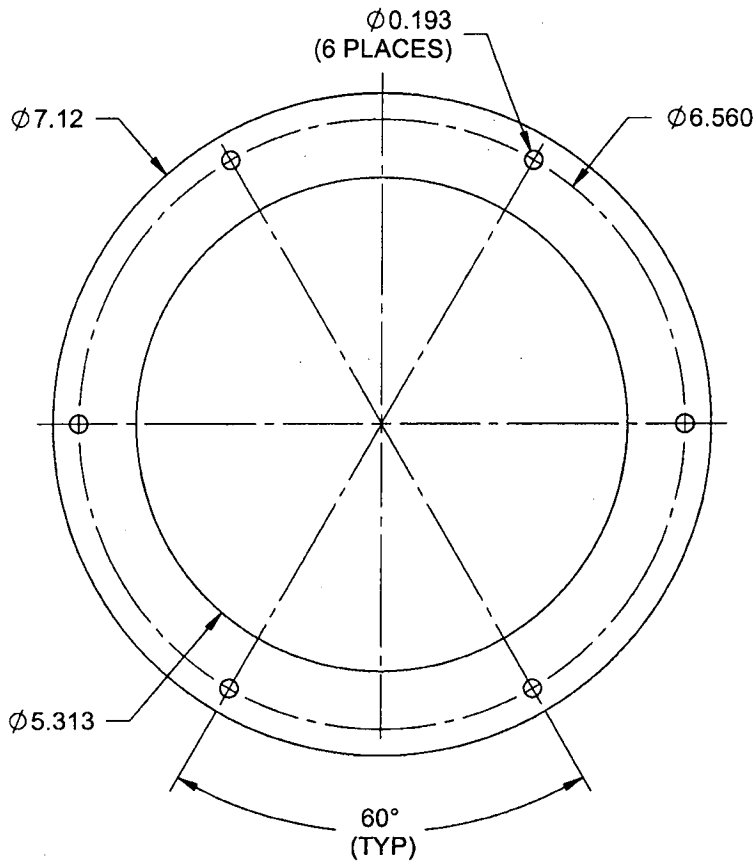
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

UNDER REVIEW

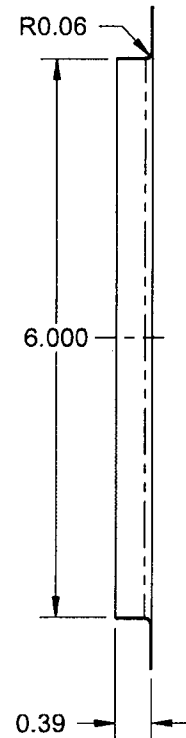
~~02.06.16~~

~~Dim + Plan Factorization~~  
~~02.06.16~~

RELEASED  
~~06.05.16~~



**D3473-9F FLANGE FLAT PATTERN**



**D3473-9 FLANGE BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

OK per REV-B  
02.06.16

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